
वस्त्रादि — हथकरघा निर्मित ग्रे या
रंगीन सूती कंबल — विशिष्टि
(दूसरा पुनरीक्षण)

**Textiles — Handloom Cotton
Blankets, Grey or
Coloured — Specification**
(*Second Revision*)

ICS 59.080.30; 97.160

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FOREWORD

This Indian Standard (Second Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Handloom and Khadi Sectional Committee had been approved by the Textiles Division Council.

This standard was first published in 1955 and subsequently revised in 1987. This standard has been again revised to incorporate the following major changes:

- a) Requirement and test method for identification of material has been incorporated;
- b) Tolerance on count of yarn has been specified;
- c) Sampling plan has been modified;
- d) References to Indian Standards have been updated; and
- e) BIS certification marking clause has been updated.

The composition of the Committee responsible for the formulation of this standard is given in Annex C.

For the purpose of deciding whether a particular requirement of this standard is complied with the final value, observed or calculated, expressing the result of a test or analysis shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard

TEXTILES — HANDLOOM COTTON BLANKETS, GREY OR COLOURED — SPECIFICATION

(Second Revision)

1 SCOPE

1.1 This standard prescribes the constructional particulars and other requirements of four varieties of handloom cotton blankets, grey or coloured.

1.2 This standard does not specify the type of finish, general appearance, lustre, feel or the colours and their combinations in coloured varieties of cloth.

2 REFERENCES

The standards listed in Annex A contain provisions which through reference in this text, constitute provision of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated in Annex A.

3 MANUFACTURE

3.1 Yarn — The yarn used in the manufacture of cloth shall be such that the cloth produced complies with requirements of this standard.

3.2 Cloth — The cloth shall be raised on both sides and raising shall be of uniform density.

3.2.1 Each transverse end of the blanket shall be whipped or hemstitched to a depth of not less than 2.5 cm, the raw edges having a turn in of 20 mm before the hem is formed. Cotton sewing thread conforming to variety number 31 of IS 1720 shall be used in hemming and the number of stitches shall be at least 30 per decimetre.

3.2.2 If agreed to between the buyer and seller, three 20 mm wide red stripes at intervals of 20 mm, the first one being 18 cm away from transverse ends, shall be inserted.

4 REQUIREMENTS

4.1 The cloth of cotton blanket of a particular variety shall conform to constructional requirements as given in Table 1.

4.2 The cloth shall also conform to the requirements given in Table 2.

Table 1 Constructional Particulars of Handloom Cotton Blankets Cloth, Grey or Coloured

(Clause 4.1)

Variety No.	Count of yarn, Universal count (Cotton count)		Ends/dm	Picks/dm	Weight per blanket	Breaking load in kg on 10.0 × 20 cm strip, N, <i>Min</i>		Length cm	Width cm	Weave
	Warp	Weft				Warp	Weft			
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)	(10)	(11)
(i)	60 tex(10 ^s)	295 to 394 tex (or 1.5 ^s to 2 ^s) soft spun waste yarn	80	60	1130	36	30	230	152	Plain/twill
(ii)	30 tex × 2 (20 ^s /2)	295 to 394 tex (or 1.5 ^s to 2 ^s) soft spun waste yarn	80	60	1130	44	30	230	152	Plain/twill
(iii)	30 tex × 2 (20 ^s /2)	295 to 394 tex (or 1.5 ^s to 2 ^s) soft spun waste yarn	60	60	775	36	30	230	152	Plain/twill
(iv)	60 tex × 2 (10 ^s /2)	295 to 394 tex (or 1.5 ^s to 2 ^s) soft spun waste yarn	50	60	875	36	30	230	152	Plain/twill
Tolerance, percent	±5	±5	±5	±5	±5	—	—	—1	—2	—
Method of test	IS 3442	IS 3442	IS 1963		Annex B	IS 1969 (Part 1)		IS 1954		Visual

Table 2 Requirements of Handloom Cotton Blankets, Grey or Coloured
(Clause 4.2)

Sl No. (1)	Characteristics (2)	Requirements (3)	Method of Test, Ref to (4)
i)	Identification of material (<i>see</i> Note)	100 percent cotton	IS 667
ii)	Colour fastness ratings to (for dyed blankets only):		
	a) Light (Change in colour)	4 or better	IS/ISO 105-B01 or IS/ISO 105-B02
	b) Washing: Test D (4)		IS/ISO 105-C10
	1) Change in colour	3 or better	
	2) Staining on cotton	3 or better	
iii)	Scouring loss, percent, <i>Max</i>		IS 1383
	a) Grey	10	
	b) Coloured	4	

NOTE — Impurities of less than 0.2 percent shall be permitted.

4.3 If in order to illustrate or specify the indeterminable characteristics such as general appearance, lustre, feel, and shade of the cloth, if a sample has been agreed upon and sealed, then the supply shall be in conformity with the sample in such respects.

4.3.1 The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

5 INSPECTION

5.1 The cloth, when visually inspected, should be reasonably free from the following defects:

- Weft crack or more than two missing picks across the width;
- Prominently noticeable weft bar due to the difference in raw material, count, twist, lustre, colour, shade, etc;
- More than two adjacent ends running parallel, broken or missing and extending beyond 15 cm;
- Prominent selvedge defects;
- Noticeable warp or weft float;
- Noticeable oil or other stains;
- Noticeable hole, cut or tear up to 3 mm in size;
- Smash rupturing the texture of the fabric; and
- Prominently noticeable dyeing defects (bars, streaks, patches, etc).

5.1.1 A reference may be made to IS 14466 for details of these defects.

6 MARKING

6.1 The cloth shall be suitably marked or labelled with the following information:

- Name of the material and variety number;
- Manufacturer's name, initials or trade-mark;

- Month and year of manufacture;
- Length and width of blanket; and
- Any other information as required by the buyer or the law in force.

6.2 BIS Certification Marking

The handloom cotton blankets conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act*, 2016 and the Rules and Regulations framed thereunder, and the handloom cotton blankets may be marked with the Standard Mark.

7 PACKING

Unless otherwise agreed upon by the buyer and the seller, the blankets shall preferably be packed in bales or cases in conformity with the procedure laid down either in IS 1347 or IS 293.

8 SAMPLING

8.1 Lot

The quantity of blankets of the same variety delivered to one buyer against one despatch note shall constitute a lot.

8.2 The conformity of the lot to the various requirements specified in the standard shall be determined on the basis of tests carried out on the samples selected from the lot.

8.3 Unless otherwise agreed, the number of pieces selected at random for inspection shall be in accordance with Table 3.

8.3.1 For selection of samples at random from the lot, procedure given in IS 4905 may be followed.

Table 3 Sample Size and Permissible Number of Non-Conforming Pieces
(*Clauses 8.3 and 8.4*)

Lot Size	Sample Size	Permissible Number of Non-Conforming Blankets	Sub-Sample Size
(1)	(2)	(3)	(4)
Up to 90	5	0	3
91 to 150	8	0	3
151 to 500	13	1	5
501 to 1 200	20	1	5
1 201 to 10 000	32	2	8
10 001 to 35 000	50	3	8
35 001 to 5 00 000	80	5	13
5 00 001 and above	125	7	13

8.4 Number of samples and criteria for conformity shall be as follows:

<i>Characteristic</i>	<i>Number of Samples</i>	<i>Criteria of Conformity</i>
Count of yarn, ends, picks, length, width and visual inspection	According to column 2 of Table 3	Number of non-conforming pieces shall not exceed the corresponding number given in column 3 of Table 3
All other requirements	According to column 4 of Table 3	All the test pieces shall meet the requirement

ANNEX A

(Clause 2)

LIST OF REFERRED INDIAN STANDARDS

<i>IS No.</i>	<i>Title</i>	<i>IS No.</i>	<i>Title</i>
293 : 1980	Code for seaworthy packaging of cotton yarn and cloth (<i>third revision</i>)	1969 (Part 1) : 2018	Textiles — Tensile properties of fabrics: Part 1 Determination of maximum force and elongation at maximum force using the strip method (<i>fourth revision</i>)
667 : 1981	Methods for identification of textile fibres (<i>first revision</i>)	3442 : 1980	Method for determination of crimp and count of yarn removed from fabrics (<i>first revision</i>)
1347 : 1972	Specification for inland packaging of cotton cloth and yarn (<i>first revision</i>)	14466 : 1997	Fabrics — Description of defects — Vocabulary
1383 : 1977	Methods for determination of scouring loss in grey and finished cotton textile materials (<i>first revision</i>)	105-B01 : 2014	Textiles — Tests for colour fastness: Part B01 Colour fastness to light: Daylight
1720 : 1978	Specification for cotton sewing threads (<i>first revision</i>)	105-B02 : 2014	Textiles — Tests for colour fastness: Part B02 Colour fastness to artificial light: Xenon arc fading lamp test
1954 : 1990	Determination of length and width of woven fabrics — Methods (<i>second revision</i>)	105-C10 : 2006	Textiles — Tests for colour fastness: Part C10 Colour fastness to washing with soap or soap and soda
1963 : 2004	Methods for determination of threads per unit length in woven fabrics (<i>second revision</i>)		

ANNEX B

(Table 1)

METHOD FOR DETERMINATION OF WEIGHT PER BLANKET

B-1 ATMOSPHERIC CONDITIONS FOR TESTING

The tests shall be carried out in a standard atmosphere at 65 ± 2 percent relative humidity and 27 ± 2 °C temperature.

B-2 CONDITIONING OF TEST SPECIMENS

B-2.1 Prior to test, the test specimens shall be conditioned to moisture equilibrium in standard atmosphere at 65 ± 2 percent relative humidity and 27 ± 2 °C temperature.

B-2.2 When the test specimens have been left in such an atmosphere for 24 h in such a way so as to expose as far as possible all portions of the test specimens to the atmosphere, they shall be deemed to have reached moisture equilibrium.

B-3 PROCEDURE

B-3.1 Determine the weight of the blanket correct to the nearest one gram.

B-3.2 Repeat the test with the remaining test specimens.

B-3.3 The mean of all values obtained as above shall be deemed to be the weight per blanket in the lot.

ANNEX C

(Foreword)

COMMITTEE COMPOSITION

Handloom and Khadi Sectional Committee, TXD 08

<i>Organization</i>	<i>Representative(s)</i>
Weavers Service Centre, Delhi	SHRI VISHESH NAUTIYAL (Chairman) SHRI VIKAS KUMAR (<i>Alternate</i>)
All India Handloom Fabrics Marketing Cooperative Society Ltd, Delhi	SHRI R. UTHAMANI SHRI SHRIKANT (<i>Alternate</i>)
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